

Date: Wednesday, 1/4/2006 2:37:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 STEP END PLATE
Job Number : 25396	
Estimate Number : 11015	
P.O. Number : N/A	Part Number : D267334
This Issue : 1/4/2006 S.O. No. : N/A	Drawing Number : D2673 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/25/2006 Qty: 200 Um: Each
Checked & Approved By : <u>SEE COMMENT BELOW</u>	
Comment : Est. C 02.01.14 Removed deburr and inspect level 5 NG/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.1913 sf(s)/Unit Total : 38.2620 sf(s)

5052-H32 .080 Sheet

5052-H32 (QQ-A-250/8) 0.080 thick.

Note: 1 Blank makes 2

Material Batch

J.F. 06/02/03
M12927 / M12872 / M12647

2.0	SHEAR	SHEAR
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Comment: SHEAR

Shear blanks: 5.10 X 3.30 +0.000/-0.010 (use off-cuts)

J.F. / J.L 06/02/03

398

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per H2673

J.F. / J.L 06/02/03

398

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / J.L 06/02/03

398

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 06/02/04 398

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

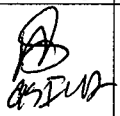
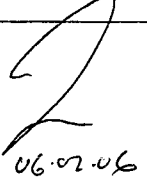
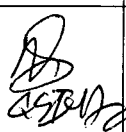
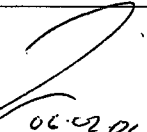
Location: WA

J.F. 02-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	3	1 stack moved while machining - 18 parts total		destroyed. No replace.	J-F 06/02/06	 06.02.06		 06.02.06

NOTE: Date & initial all entries

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Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

508 06/02/08

(598)

D9 06/02/07

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25396
Description: End Plate		Part Number:	D2673-34
Inspection Dwg: D2673 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by:	JF	Audited by:	SA	Prototype Approval:	N/A
Date:	06/02/01	Date:	06.02.01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM	



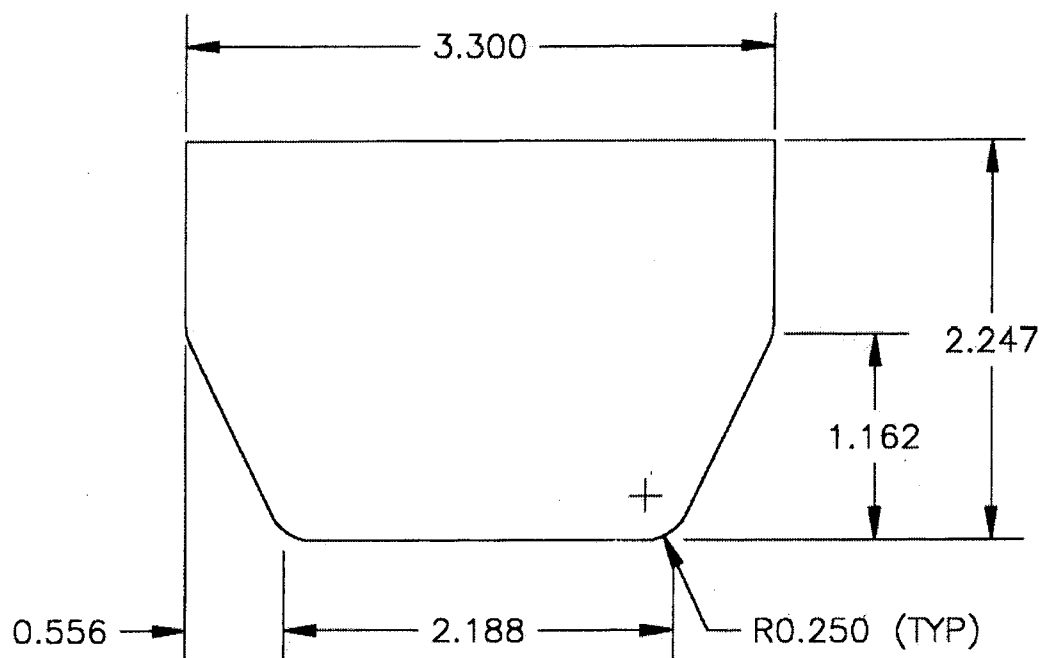
DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2673	REV. A SHEET 1 OF 1
DATE 97:05:06		TITLE END PLATE	SCALE 1:1

RELEASED
97p5/α BW

UNDER REVIEW

01.07.15 CP OK 05.07.14
DESIGN OK, BUT CHECK WITH
JIS BEFORE MANUFACTURE

END PLATE FOR D2244 EXTRUSION CUT AT 34°



D2673-34

MATERIAL: 5052-H32 QQ-A-250/8 0.080 THICK ENGINEERING

SHOP COPY
RETURN TO
UNCONTROLLED
SUBJECT TO
WORK

NO 25396

